•••						- Ghi	PM	Parch	_	
Work Orde February-07-13	er ID 96834 8:24:39 AM			*968	334*	ŕ	/"	25		Page I
Revision ID:	D3935-3 Pylon Wall Protector, LI	<del>1</del>		Accept	*N900	04010	<b>n</b> * '	Setup Start Stop	ĮVI.	S1*
Start Date: Required Date: Reference:		ty: 10.00 Qty: 10.00	*10* *10*		Cust Item II Customer:	D:		·	····IN.	S2*
	Process Plan: M	r 2	Date: 13:02-02	Tooling: SPC (Y/N):		ite:	I	Run Start Stop	" <b> \</b>	R1* R2*
Sequence ID/ Work Center ID		tion		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	• 					-			
D3935	В			0.00						
*100* Waterjet FLOW CNC Waterjet		Memo 1-Cut as per l Dwg Rev: Prog Rev:	Dwg D3935	0.00			10_			J <u>m13-2-21</u>

110

QC2- Inspect parts off machine FAI/FAIB

2- Deburr if necessary

0.00

\*110\*

QC Quality Control

Memo

0.00

10 0 JMB-2.21

**WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Water Jet Skid-tube Crosstube Rework Prod. Eng. Coor. Small Fab Machining Part No. Scrap Rec/Store/Packaging Thermoforming Finishing Use-as-is Supplier Large Fab Composite Work Order Update NCR No. Action Sign & Description of work order update Initial Root **Chief Eng** Date Verification Description or Non-conformance Qty Cause Date Step Doc/Data Equip/Tooling

## Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Ovalized Bend Grain Bending Over/Under tolerance Temperature/Cure BOM/Route Hardware Centre Not Concentric to O/S

DQA:

Date:

Engineering

Quality

Other

QC Inspector

Broken/Damaged Part Incorrect Weld Inspection Incomplete Cracks Wrong Stock Pulled Part Lost/Missing Instructions Incomplete/Unclear Crushed/Crimped Burrs Part Moved Contamination Mainteriance Cuffs Positioned Wrong Countersink Mislabeled Heat Treat Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread **Drill Holes** Offset Ripples in Bend Torque Waves in Extrusion **Out of Calibration** Drawing Out of Sequence Finish **Turning Sequence** Folio **Outside Dimensions** 

Wave/Twist in Tube

Operator Material

\*96834\*

Page 2

February-07-13 8:24:39 AM Item ID: D3935-3 Accept \*N900040100\* Setup Start \*NC1\* **Revision ID:** Item Name: Pylon Wall Protector, LH **Start Date:** 2/07/13 **Start Qty:** 10.00 \*10\* **Cust Item ID:** Required Date: 3/22/13 Req'd Qty: 10.00 **Customer:** Reference: Run Approvals: **Process Plan:** Date: Tooling: Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 120 QC8- Inspect parts - second check \*120\* Memo Quality Control Identify as per dwg & Stock Location: STON A. 130 \*130\* Packaging Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 \*140\* 0.00 Memo Quality Control

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** Yes / No NCR: QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Crosstube Water Jet Engineering Skid-tube Rework Machining Small Fab Prod. Eng. Coor. Quality Scrap Part No. Rec/Store/Packaging Other Use-as-is **Thermoforming** Finishing Supplier Work Order Update Large Fab Composite NCR No. Action Sign & Description of work order update Initial Root Verification **Chief Eng** Description Date QC Inspector Qty or Non-conformance Step Date Cause Doc/Data Equip/Tooling Operator Material Setup

				FAUL	T CATEGORY			
Landing	Gear		General			 _	_	_
Γ	Bending		Bend		Grain	Ovalized	L	Pressure/Forced
	Centre Not Concentric to O/S	П	BOM/Route		Hardware:	Over/Under tolerance	L	Temperature/Cure
-	Cracks		Broken/Damaged		Inspection Incomplete	Part Incorrect		Weld
	Crushed/Crimped		Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	L	Wrong Stock Pulled
	Cuffs		Contamination		Maintenance	Part Moved		
	Heat Treat		Countersink		Mislabeled	Positioned Wrong		_
	Inspection Strip in Tube		Cut Too Short		Misread	Power Loss/Surge		Other
	Ripples in Bend	Г	Drill Holes		Offset			
	Torque Waves in Extrusion		Drawing		Out of Calibration			
	Turning Sequence		Finish		Out of Sequence			
	Wave/Twist in Tube		Folio		Outside Dimensions			

Other
Process
Supplier
Training
Unapproved

Work Order ID: 96834

\*96834\*

Parent Item:

D3935-3

\*D3935-3\*

Parent Item Name: Pylon Wall Protector, LH

**Start Date: 2/07/13** 

Required Date: 3/22/13

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item 1D/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item		Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No	- · — ··• ·		100	sf	11.6273	8.5323	89 81368			
*MI FXS 1		N29-N4	*						**	90		(	JMB-2-21

GE PLASTICS LEXAN SHEET

<u>Location</u>	Loc Oty	Loc Code
MAT019	11.6273	
121803	_11.6273	

124654

124654

Page 1

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Water Jet Engineering Crosstube Rework Quality Small Fab Prod. Eng. Coor. Machining Part No. Scrap Rec/Store/Packaging Thermoforming Finishing Other Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Description of work order update Action Sign & Initial Root Verification QC Inspector Qty Chief Eng Description Date or Non-conformance Cause Date Step Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Ovalized Bend Grain Bending Temperature/Cure BOM/Route Over/Under tolerance Hardware Centre Not Concentric to O/S Weld Broken/Damaged Part Incorrect Inspection Incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Maintenance Part Moved Cuffs Contamination

Mislabeled

Out of Calibration

Out of Sequence

**Outside Dimensions** 

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

**Torque Waves in Extrusion** 

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	96834
Description: Pylon Wall Protector, LH	Part Number:	D3935-3
Inspection Dwg: D3935 Rev: B		Page 1 of 1

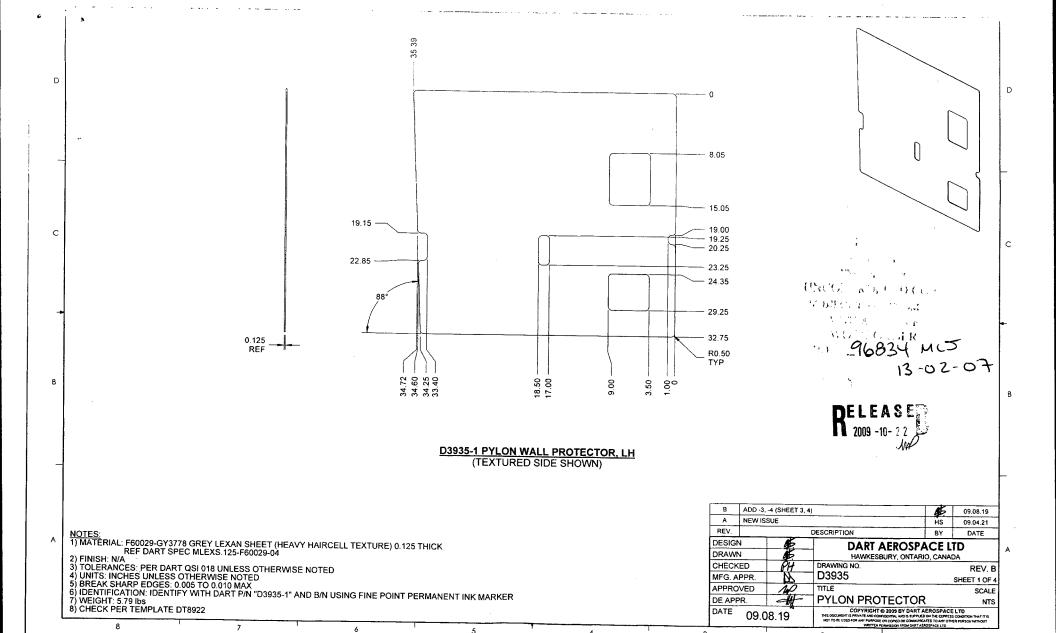
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.68	+/-0.030	5.68"	-		V	Jkmai
12.68	+/-0.030	12.68"	_		7	
18.75	+/-0.030	18.75"	-		T	
19.00	+/-0.030	19.00	_		T	
20.25	+/-0.030	20.25	_		Т	
22.75	+/-0.030	22.75"	-		<b>T</b>	. e. e. Mer .
23.73	+/-0.030	23.73'-	_		T	
28.63	+/-0.030	25,63"	_		+	
32.75	+/-0.030	32.75	_		T	
1.00	+/-0.030	1.00 "	_		γ	
3.50	+/-0.030	3.50"	-		V	
9.00	+/-0.030	9.00"	-		V	
17.00	+/-0.030	1700"	_		て	
18.50	+/-0.030	18.50"	-		Ť	
33.40	+/-0.030	33.40	-		Ť	
34.25	+/-0.030	34.25	_		T	
34.60	+/-0.030	34.60°	_		T	*
34.72	+/-0.030	34.32"	-		T	
22.85	+/-0.030	22.85"	_		T	,:** - · ,
19.15	+/-0.030	19.15	-		<u> </u>	
35.39	+/-0.030	35,39	_		Ť	\$.2°. 1. **
0.125	+/-0.010	0.196,	_		V	
						-
						. •
			OAS.			

Measured by:	Jm	Audited by:	Prototype Approval:	N/A
Date:	13-2-21	Date: 13 3 31	Date:	N/A

Rev	Date	Change	Revised b	ax I	Approved
Α	09.11.17	New Issue			M
			7	7	



96834 8.05 -15.05 19.00 19.25 19.15 20.25 23.25 - 22.85 24.35 29.25 32.75 0.125 R0.50 REF 20 8 14.70 33.40 34.25 34.60 34.72 D3935-2 PYLON WALL PROTECTOR, RH (TEXTURED SIDE SHOWN) NOTES: 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK REF DART SPEC MLEXS.125-F60029-04 DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-2" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 5.79 lbs
8) CHECK PER TEMPLATE DT8923 DRAWN DRAWING NO. CHECKED REV. B D3935 MFG. APPR. SHEET 2 OF 4 APPROVED TITLE SCALE

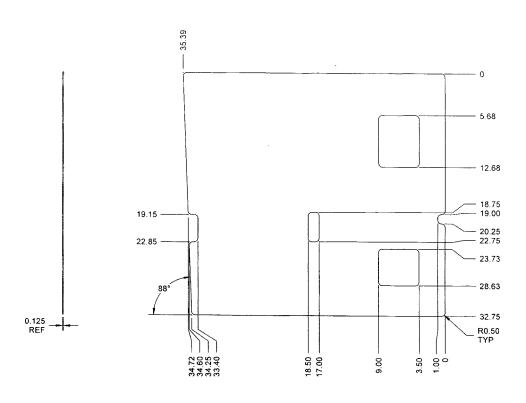
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DE APPR. PYLON PROTECTOR NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD
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D3935-3 PYLON WALL PROTECTOR, LH (TEXTURED SIDE SHOWN)

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK REF DART SPEC MLEXS.125-F60029-04

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В

REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-3" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 5.79 lbs
8) CHECK PER TEMPLATE DT9527

DESIGN DRAWN		DART AEROSPACE LTD				
		HAWKESBURY, ONTARIO, CANADA				
CHECKED	PH	DRAWING NO.	REV. B			
MFG. APPR.	77	D3935	SHEET 3 OF 4			
APPROVED APPR.		TITLE	SCALE			
		PYLON PROTECTOR	NTS			
DATE 09.0	08.19	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENTS RYMATE AND COMPOSITION, AND IS SUPPLIED ON EXPRESS COMMON THAT IT IS NOT TO BE USED FOR HAM PROMOSE OR COMPOSITION TO HAM PRISON WITHOUT				

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